

Date: 17/09/2007 11:15:40 AM
 User: Linda Lapelle

Process Sheet

Split
SP 07/09/2007

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	INLET ADAPTER
Job Number :	34069		
Estimate Number :	12174		
P.O. Number :	N/A	Part Number :	D3478041
This Issue :	17/08/2007	S.O. No. :	N/A
First Rev. :	NC	Drawing Number :	D3478 REV B
First Issue :	1/1	Project Number :	N/A
Previous Run :	28520	Drawing Revision :	B
		Type :	SMALL / MED FAB
		Material :	N/A
		Due Date :	11/09/2007
Written By :	Qty: 4 Um: Each		
Checked & Approved By :	<i>AD 08 20</i>		
Comment :	Est Rev: A New Issue 06-02-03 JLM		
	Est Rev: B As per Rev B 06-05-24 JLM		

Additional Product:

Part Number



Sep. #	Machine Or Operation:	Description :
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10	D34783	TUBE
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Comment: Qty: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3478-3	Tube	<i>B 28570</i>

mf

11	D34781	FLANGE
----	--------	--------



Comment: Qty: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3478-1	Flange	<i>B 34086</i>

mf 07-09-20

30	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3478

2-Spot Weld as per Dwg D3478 and Dart QSI 018

mf 07-09-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/09/26	3	split w/o	SB	07/09/26	1		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/09/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng.	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Friday, 17/08/2007 11:19:46 AM

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INLET ADAPTER

Job Number: 34069

Part Number: D3478041

Job Number



Seq. #:

Machine Or Operation:

Description :

4.0

QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

SB 07/09/20

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/09/20

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

W 07.09.26

Identify with a permanent fine point marker and Stock

Location: _____

7.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

①
D 07/09/20

Job Complete



W 07.09.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

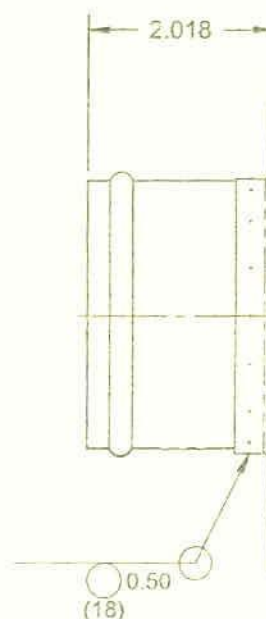
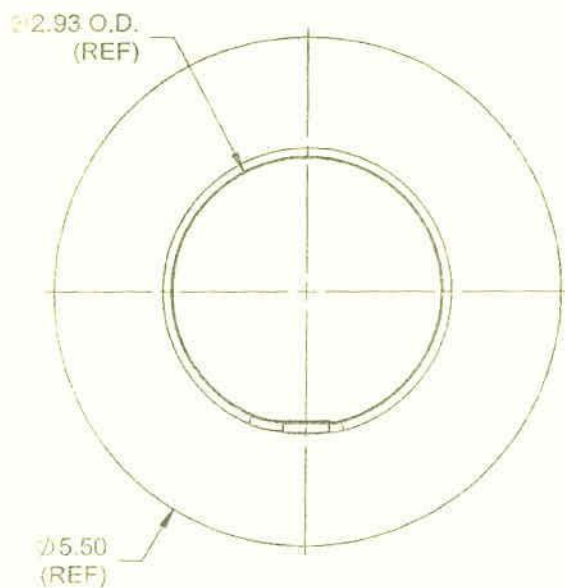
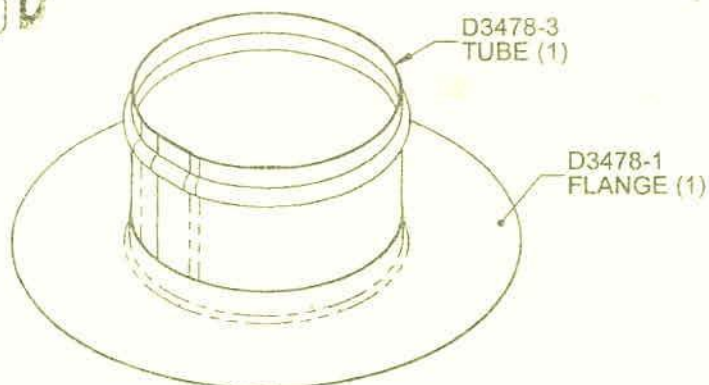
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 111	APPROVED 111	DRAWING NO. D3478	REV. B SHEET 1 OF 7
DATE 06.05.16		TITLE AIR INLET ADAPTER	SCALE 1:2
A	05.12.08	NEW ISSUE	
B	06.05.16	REDESIGN D3478-5, ADD D3478-7, D3478-9S/-9	

RELEASED
06.05.16



D3478-041 AIR INLET ADAPTER

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3478-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3478-041	AIR INLET ADAPTER
1	D3478-1	FLANGE
1	D3478-3	TUBE

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LIBRARY
1000 S. EAST ASIAN BLDG.
CHICAGO, ILL. 60607
TEL. 773-936-5000
FAX 773-936-5001
WWW.CHICAGO.EDU

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SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 17

EMPLOYEE: Melanie Fauteux

PART NUMBER: D3478-041

JOB NUMBER: B 34069

MATERIAL TYPE: 304L

MATERIAL THICKNESS: 0.18

GROUP SPECIFICATION



Group 1: Aluminum & magnesium



Group 2: Iron; nickel; cobalt



Group 3: Titanium

TEST RESULTS

	PASS	FAIL
VISUAL:	[<u>—</u>]	[]
PENETRATION:	[<u>—</u>]	[]
PULL STRENGTH:	[<u>—</u>]	[]

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/02/24
QUALIFIER: 875

Handwritten text, likely a list or index, written in cursive script. The text is arranged in several columns and rows, with some lines appearing to be numbered or dated. The handwriting is dense and difficult to decipher due to the cursive style and the age of the document.